

Date: Thursday, 19/02/2009 3:32:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 45916	
Estimate Number : 13458	
P.O. Number :	Part Number : D34175
This Issue : 19/02/2009 S.O. No. :	Drawing Number : D3417 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 44350	Material :
Written By :	Due Date : 03/03/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 09.02.19</u>	
Comment : Est Rev:A New issue 08-07-09 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MDELNR12500

DELIN ROUND BAR 1.25"

**Comment:** Qty.: 0.0311 f(s)/Unit Total : 0.6216 f(s)

Material: Delrin Round Bar Ø1.250

(M-DELIN-R1.250)

Batch: M110252

Identify for D3417-3

MS 09/02/23

2.0

~~HARDINGE~~DOOSAN

HARDINGE CNC LATHE SMALL

**Comment:** HARDINGE CNC LATHE SMALL

DOOSAN MS 09.02.20

1-Turn as per Folio FA761 Rev: 1/9 & Dwg D3417 Rev: 0

2-Deburr

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MS 09/02/23 (20)

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

MS 09/02/23 (20)

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST 405 92

MS 09/02/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 3:32:16 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 45916

Part Number: D34175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-23

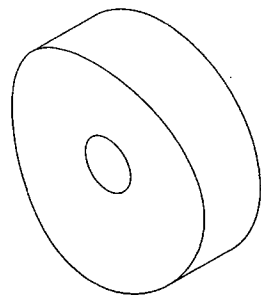
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

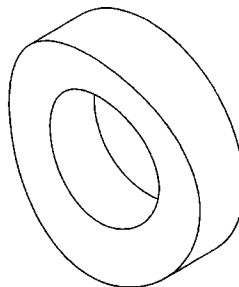
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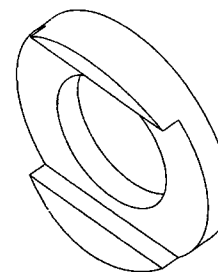
NOTE: Date & initial all entries



D3417-1 WASHER



D3417-3 WASHER







D3417-5 WASHER 

NO. 15910
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3417-1, 0.02 lbs
D3417-3, 0.01 lbs
D3417-5, 0.01 lbs

RELEASED
06-08-01-17

D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3417	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	08.07.08	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

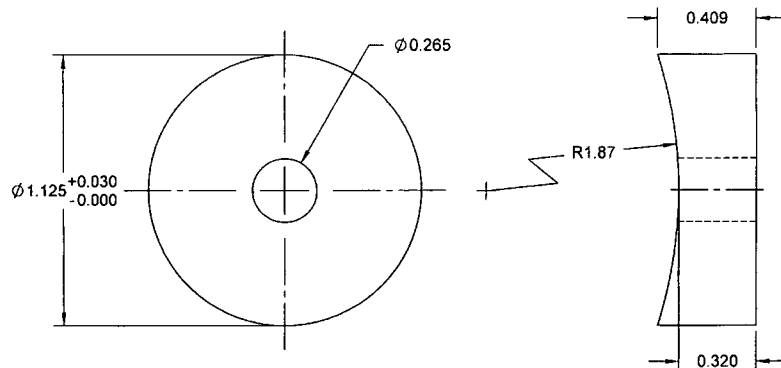
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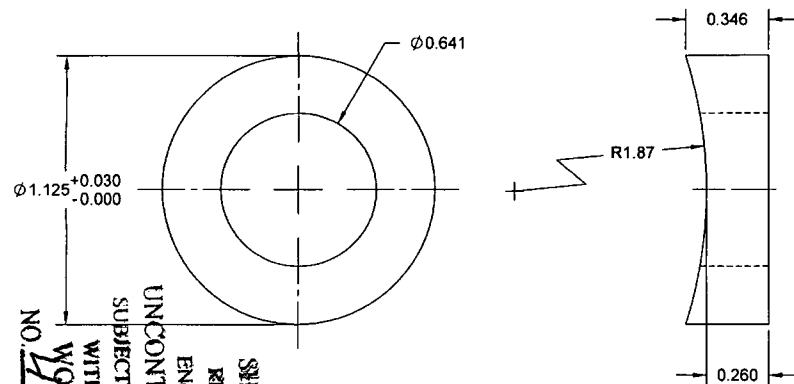
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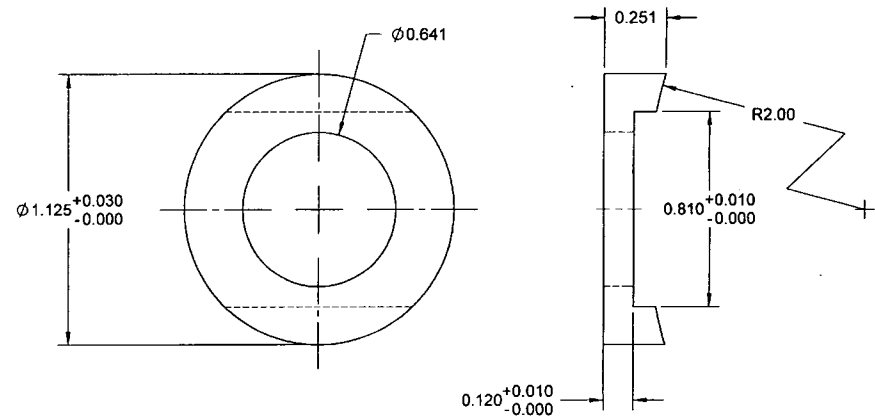
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D3417-1 WASHER








D3417-3 WASHER



D3417-5 WASHER

RELEASED
06-06-01 KJP

NO. 15916
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SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3417	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	08.07.08	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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